

Date: Tuesday, 06/01/2009 10:04:23 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE SIDE LH (206 HI-SLOPE)
Job Number : 44391	
Estimate Number : 11000	
P.O. Number :	Part Number : D26021 <i>D2601-1</i>
This Issue : 06/01/2009 S.O. No. :	Drawing Number : D2602 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 43752	Material :
Written By :	Due Date : 31/01/2009 Qty: 4 Um: Each
Checked & Approved By : <i>JUD 09.01.06</i>	
Comment : Est. D 04.02.25 Reformat KJ/RF	
Note: Issue with part number D2602-2	
Est Rev:E Now On Waterjet 07-03-22 JLM	
Est Rev:F RevB as per dwg ECN1059 DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 1.4146 sf(s)/Unit Total : 5.6582 sf(s)
 2024-T3 .040 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040) Batch *110337* *B 9-2-12*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2602
 *****Same Cutting File for -1 & -2 *****
 Dwg Rev: *B*
 Prog Rev: *B* *B 9-2-12*
 2-Deburr if necessary *B 9-2-12*

7

P.T.O

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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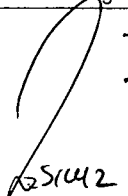
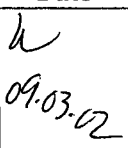





Comment: SECOND CHECK

50103/04 *(47)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2601-1 PAR #: N/A Fault Category: Prod/Eng Coord. work NCR: Yes No DQA: W Date: 08/03/10
 Resolution: Process/Revise Disposition: re-work QA: N/C Closed: W Date: 09/03/10

NCR: <u>44391</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-03-02	2.0	Incorrect parts made. D2602 as D2601. Employee worked off of the dwg & the incorrect dwg was attached to the w/o. Affected w/o's: 45390, 44391, 45391 & 44392	 125142	- See NCR 09-027 - update w/o to a D2601	 09-03-02	 09-03-02	 125142	 09-03-02

NOTE: Date & initial all entries

Date: Tuesday, 06/01/2009 10:04:23 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 44391

Part Number: D26021

D26021.1

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D2602

SD 09/03/04

(7)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 02/03/06

(X7) (-1)
(+6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

CMO/BR

09/03/09

(X7)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q.M 09-03-06

(2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9/3/10

(7K)

SD

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/10

Job Completion



MF
09-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44391
Description: CONSOLE SIDE		Part Number: D2601-1
Inspection Dwg: D2601 Rev: B		Page 1 of 1

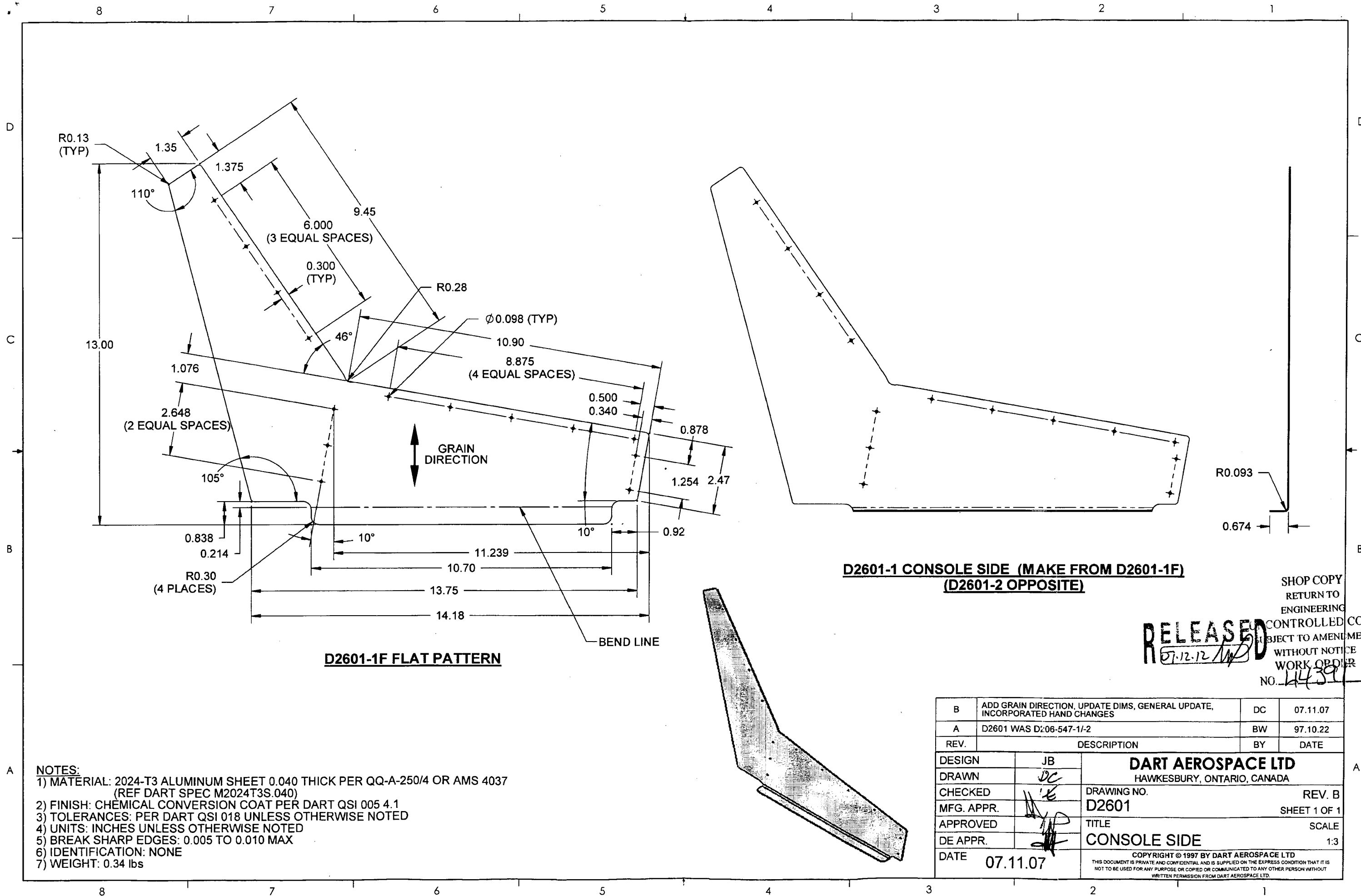
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.101				
13.00	+/- .030	12.981				
1.35	+/- .030	1.352				
1.375	+/- .010	1.372				
.300	+/- .010	.301				
6.000	+/- .010	5.994				
9.45	+/- .030	9.45				
10.96	+/- .030	10.96				
8.875	+/- .010	8.878				
.340	+/- .010	.338				
.500	+/- .010	.500				
.875	+/- .010	.880				
1.254	+/- .010	1.247				
2.47	+/- .030	2.483				
.92	+/- .030	.911				
11.239	+/- .010	11.221				
10.70	+/- .030	10.694				
13.75	+/- .030	13.75				
14.18	+/- .030	14.18				
.838	+/- .010	.838				
2.648	+/- .010	2.656				
.640	+/- .010	.646				

Measured by: JB	Audited by: S	Prototype Approval: n
Date: 9-3-3	Date: 02/08/04	Date: 9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D2601-1 CONSOLE SIDE (MAKE FROM D2601-1F)
(D2601-2 OPPOSITE)

D2601-1F FLAT PATTERN

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.34 lbs

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4439

B	ADD GRAIN DIRECTION, UPDATE DIMS, GENERAL UPDATE, INCORPORATED HAND CHANGES	DC	07.11.07
A	D2601 WAS D206-547-1/2	BW	97.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	JE	DRAWING NO.	REV. B
MFG. APPR.		D2601	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CONSOLE SIDE	1:3
DATE	07.11.07	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	